



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D350-591-121**  
**Job Sheet 174176**



Part No: D350-591-121

Job Qty: 4 ea **3**

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/12/18

Job Tracking No:

Due Date: 4/4/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG IIN-D350-591 REV H, D2351-041 REV E IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF IPP rev. F 06.02.23 added grinding EC

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation           | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off      |
|-------|---------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|---------------|
|       |                     |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |               |
| 90    | Start up Operation  | 4 Ea  |            | 4/3/18   | 0.00      | 0.00    | Start Up Large Fab-4  |           | DC 2018-04-06 |
| 110   | Large Fab           | 4 pcs |            | 4/3/18   | 0.00      | 2.72    | Large Fab 8           |           | DC 2018-04-06 |
| 120   | CNC Bend Skid tubes | 4 pcs |            | 4/3/18   | 0.38      | 1.17    | CNC Bend Skid tube    |           | SL            |
| 122   | QC                  | 4 pcs |            | 4/3/18   | 0.00      | 0.00    | QC5                   |           | PD 18-04-10   |
| 140   | Large Fab           | 4 pcs |            | 4/3/18   | 0.00      | 2.72    | Large Fab 2           |           | SL            |
| 150   | QC                  | 4 pcs |            | 4/3/18   | 0.00      | 0.00    | QC9                   |           | PD 18-04-12   |
| 160   | QC                  | 4 pcs |            | 4/3/18   | 0.00      | 0.00    | QC5                   |           | PD 18-04-12   |
| 170   | HandFinish          | 4 pcs |            | 4/3/18   | 0.00      | 0.74    | HandFinish1           |           | SA 18-04-12   |
| 180   | QC                  | 4 pcs |            | 4/3/18   | 0.00      | 0.00    | QC7-2                 |           | 38            |
| 190   | Large Fab           | 4 pcs |            | 4/3/18   | 0.00      | 2.72    | Large Fab 2           |           | SL            |
| 220   | QC                  | 4 pcs |            | 4/3/18   | 0.00      | 0.00    | QC10                  |           | CPC           |
| 230   | QC                  | 4 pcs |            | 4/3/18   | 0.00      | 0.00    | QC5                   |           | CPC           |
| 240   | HandFinish          | 4 pcs |            | 4/3/18   | 0.00      | 0.74    | HandFinish1           |           | SA 18-04-18   |
| 250   | Powdercoat          | 4 pcs |            | 4/3/18   | 0.00      | 0.65    | Powdercoat1           |           | BR 18-4-18    |
| 260   | HandFinish          | 4 pcs |            | 4/4/18   | 0.00      | 0.74    | HandFinish3           |           | DEB 18-04-18  |
| 270   | QC                  | 4 pcs |            | 4/4/18   | 0.00      | 0.00    | QC3                   |           | SL            |
| 280   | Packaging           | 4 pcs |            | 4/4/18   | 0.00      | 0.00    | Packaging1-3          |           | DAS           |
| 290   | QC                  | 4 pcs |            | 4/4/18   | 0.00      | 0.00    | QC4                   |           | 58            |
| 295   | DC                  | 4 pcs |            | 4/4/18   | 0.00      | 0.00    | DC                    |           | 9-89 DAS      |
| 300   | Packaging           | 4 pcs |            | 4/4/18   | 0.00      | 0.00    | Packaging3-1          |           | 9-89 DAS      |
| 310   | QC21-FG             | 4 Ea  |            | 4/4/18   | 0.00      | 0.00    | QC21                  |           | 9-89 DAS      |

Part Op 110 - 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 2- Drill holes as per dwg using DT8230.

Descriptions: 120 - Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041. Use DT8033 jig to make sure bend is good and fits the jig.

140 - 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033 A/RAluminum Rod 3-Do not Grind Flush

190 - 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod 3-Grind end plate flush.

250 - START TIME: 10:40 OVEN TEMPERATURE: 320° FINISH TIME: 11:10

295 - Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

300 - Identify and pack for shipping as per PPP D350-591-121 Location:FG039

P.T.O.

APR 19 2018  
(16)

Wing walk #138761

505878 / x3 xLH

Ex 3/12/18 12:37 PM dart.lacelle.linda



# WORK ORDER NON-CONFORMANCE / UPDATE



Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_

**DAS**  
**53**  
**9-89**

Date: **AUG 15 2018**

Work Order update only ☐

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| Work Order: <u>17476</u><br><br>Part No. <u>D350-591-121</u><br><br>NCR No. <u>18-6936</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             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<td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input checked="" type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |                                                                                |                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Skid-tube <input type="checkbox"/> | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input checked="" type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                                 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| Thermoforming <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Large Fab <input checked="" type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | MRB (QSI042) Approval<br><b>DAS</b><br><b>9</b><br><b>9-89</b> <u>18-04-10</u> |                                                                                                                                                                                                                                                |                                                                 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| <b>Description Work Order Deviation</b><br><br><u>Qty 1 is over bend</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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type="checkbox"/></td></tr> <tr><td>Wrong Stock Pulled</td><td><input type="checkbox"/></td></tr> <tr><td>Out of Sequence</td><td><input type="checkbox"/></td></tr> <tr><td>Off-set</td><td><input type="checkbox"/></td></tr> <tr><td>Mislabeled</td><td><input type="checkbox"/></td></tr> <tr><td>Fit/Function</td><td><input type="checkbox"/></td></tr> <tr><td>Misaligned/off center</td><td><input type="checkbox"/></td></tr> </table> | Power Loss/Surge                | <input type="checkbox"/> | Folio/Program | <input type="checkbox"/> | Grain                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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| Finish                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Misread                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                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| Turning Sequence                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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610

### Job BOM

| Part / Item   | Component Name            | Quantity      | Operation             | Container |
|---------------|---------------------------|---------------|-----------------------|-----------|
| D2244-116     | Step Extrusion            | 2 Ea (.5 ea)  | 90-Start up Operation | 5014582   |
| D2850-1       | End Bracket               | 4 Ea (1 ea)   | 140-Large Fab         | 0149901   |
| D2582         | Hi-Skid Step Leg Assembly | 4 Ea (1 ea)   | 190-Large Fab         |           |
| D2673-34      | End Plate                 | 4 Ea (1 ea)   | 190-Large Fab         | 5042088   |
| MS20600-AD4W3 | Cherry Rivet              | 64 Ea (16 ea) | 190-Large Fab         | 5000552   |
| AN3-37A       | Bolt                      | 8 Ea (2 ea)   | 280-Packaging         |           |
| AN4-13A       | Bolt                      | 4 Ea (1 ea)   | 280-Packaging         |           |
| AN4-16A       | Bolt                      | 8 Ea (2 ea)   | 280-Packaging         |           |
| D2230-1       | Mounting Lug              | 4 Ea (1 ea)   | 280-Packaging         |           |
| D2230-3       | Mounting Lug              | 4 Ea (1 ea)   | 280-Packaging         |           |
| D2732-030     | Rubber Cushion - 3"       | 8 Ea (2 ea)   | 280-Packaging         |           |
| MS21042L3     | Nut                       | 8 Ea (2 ea)   | 280-Packaging         |           |
| MS21042L4     | Nut                       | 12 Ea (3 ea)  | 280-Packaging         |           |
| NAS1149D0363J | Washer                    | 16 Ea (4 ea)  | 280-Packaging         |           |
| NAS1149D0463J | Washer                    | 24 Ea (6 ea)  | 280-Packaging         |           |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D2244-116      | 2        | 168       | 0         |
| 140-Large Fab         | D2850-1        | 4        | 4         | 0         |
| 190-Large Fab         | D2582          | 4        | 1         | 0         |
|                       | D2673-34       | 4        | 19        | 0         |
|                       | MS20600-AD4W3  | 64       | 217       | 0         |
| 280-Packaging         | AN3-37A        | 8        | 85        | 0         |
|                       | AN4-13A        | 4        | 807       | 0         |
|                       | AN4-16A        | 8        | 345       | 0         |
|                       | D2230-1        | 4        | 44        | 0         |
|                       | D2230-3        | 4        | 107       | 0         |
|                       | D2732-030      | 8        | 255       | 0         |
|                       | MS21042L3      | 8        | 3,144     | 0         |
|                       | MS21042L4      | 12       | 3,511     | 0         |
|                       | NAS1149D0363J  | 16       | 3,299     | 0         |
|                       | NAS1149D0463J  | 24       | 4,644     | 0         |

### Part Specifications

Specifications could not be found.

# WORK ORDER NON-CONFORMANCE / UPDATE



DATE: \_\_\_\_\_ Date: \_\_\_\_\_

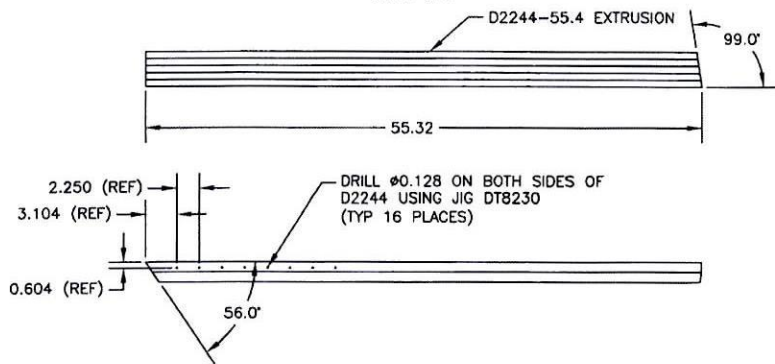
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

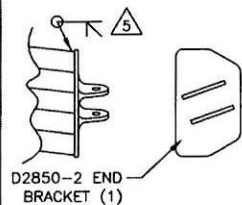
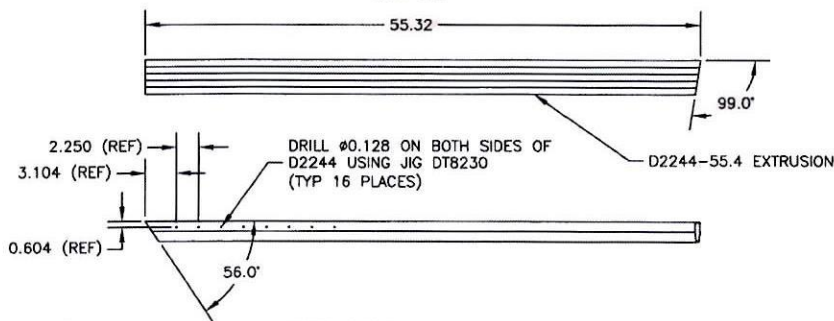
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Step #:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | QTY Effective :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | MRB (QSI042) Approval                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Completed By                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
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|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | QC / QA Coordinator Approval                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | FAULT CATEGORY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/> | No Re-verification <input type="checkbox"/><br>Operator <input type="checkbox"/><br>Offset/Setup <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not Concentric <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Temperature/Cure <input type="checkbox"/><br>Set-up <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set <input type="checkbox"/><br>Mislabeled <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Misread <input type="checkbox"/><br>Turning Sequence <input type="checkbox"/> |
| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                   |



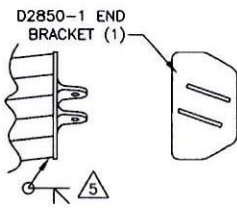
D2351-2 CUTTING/DRILLING DETAIL  
RIGHT STEP



D2351-1 CUTTING/DRILLING DETAIL  
LEFT STEP



DETAIL A  
SCALE: 1:4

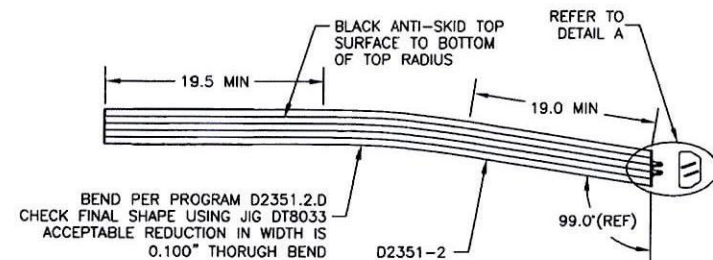


DETAIL B  
SCALE: 1:4

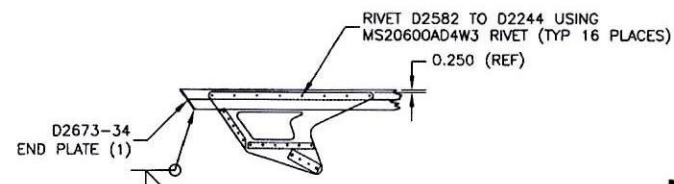
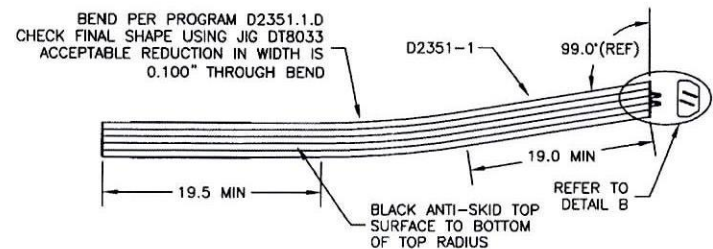
D2582 STEP LEG ASSEMBLY (1)



D2351-042 BENDING/ASSEMBLY DETAIL  
RIGHT STEP



D2351-041 BENDING/ASSEMBLY DETAIL  
LEFT STEP



GENERAL NOTES

- 1) WELD PER DART QSI 004
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
  - 3) ALL DIMENSIONS ARE IN INCHES
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

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|          |          |                          |                     |
|----------|----------|--------------------------|---------------------|
| DESIGN   | DRAWN BY | DART                     | DART AEROSPACE LTD. |
| KE       | PH       |                          |                     |
| CHECKED  | APPROVED | DRAWING NO.              | REV. E              |
|          |          | D2351                    | SHEET 2 OF 2        |
| DATE     |          | TITLE                    | SCALE               |
| 05.11.14 |          | HIGH FLOAT STEP ASSEMBLY | 1:12                |

RELEASED  
05.11.14

UNDER REVIEW



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 813 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Container No: S058781



Part: D350-591-121

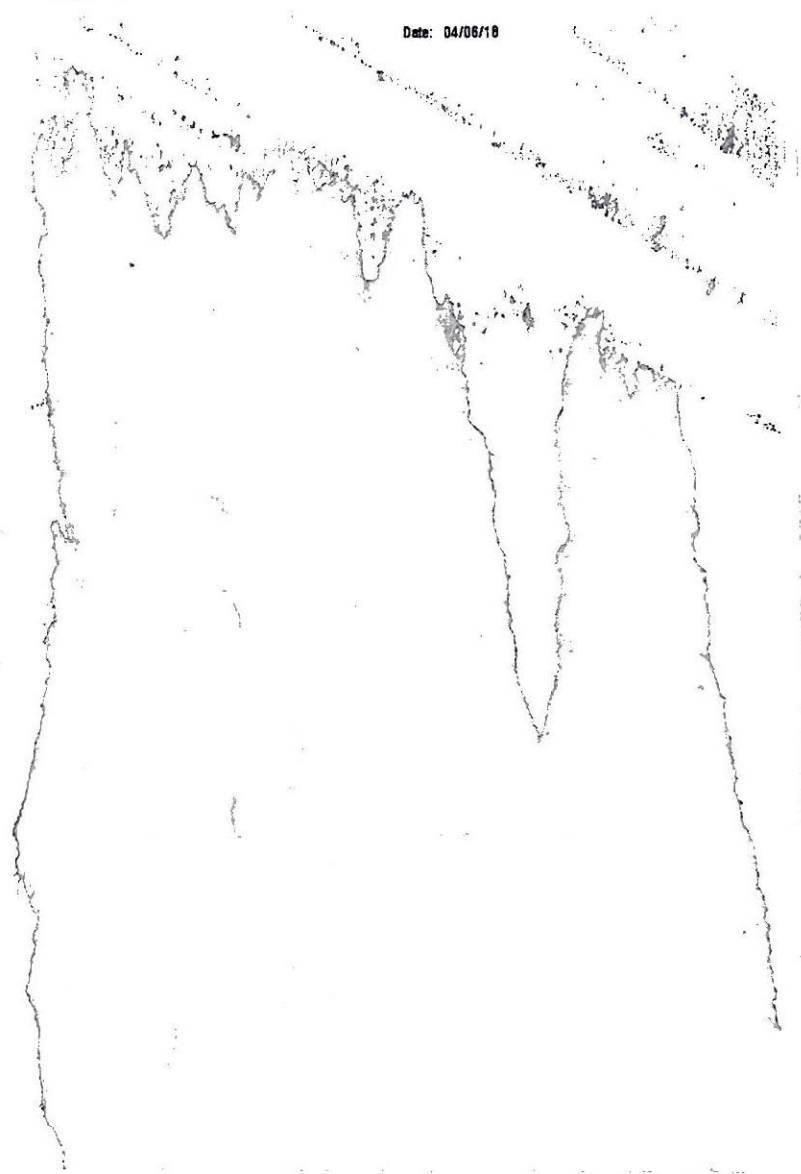
Job No: 174176

Serial No/Batch: S058781

Revision:

Inspector:

Date: 04/06/18





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

## Container View (Active) - Master Unit Containers

| Master Unit No | Container No | Part No       | Part Name           | From Container | Current Location | Quantity |
|----------------|--------------|---------------|---------------------|----------------|------------------|----------|
| 002599         | S062364      | AN3-37A       | Bolt                | S034387 ✓      | ST347            | 6        |
| 002599         | S062363      | AN4-13A       | Bolt                | S045860 ✓      | ST344            | 3        |
| 002599         | S062360      | AN4-16A       | Bolt                | S041125 ✓      | ST343            | 6        |
| 002599         | S062359      | D2230-1       | Mounting Lug        | S059886 ✓      | ST521            | 3        |
| 002599         | S062357      | D2230-3       | Mounting Lug        | S051382 ✓      | ST521            | 3        |
| 002599         | S062355      | D2732-030     | Rubber Cushion - 3" | S044807 ✓      | ST410            | 6        |
| 002599         | S062354      | MS21042L3     | Nut                 | s038764 ✓      | ST303            | 6        |
| 002599         | S062352      | MS21042L4     | Nut                 | S045901 ✓      | ST303            | 9        |
| 002599         | S062350      | NAS1149D0363J | Washer              | S015269 ✓      | ST263            | 12       |
| 002599         | S062349      | NAS1149D0463J | Washer              | S045845 ✓      | ST263            | 18       |

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/18/18 11:17 AM dart.quirion.sonia

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PAGE 1 OF 1

Part Number: D350-591-121

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH

[illegible]



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                   | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Step #:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | QTY Effective :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | MRB (QSI042) Approval                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Completed By                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Lead hand / Supervisor Approval Verification                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | QC / QA Coordinator Approval                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | FAULT CATEGORY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                   |
| Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/> | No Re-verification <input type="checkbox"/><br>Operator <input type="checkbox"/><br>Offset/Setup <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not Concentric <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Temperature/Cure <input type="checkbox"/><br>Set-up <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set <input type="checkbox"/><br>Misabeled <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Misread <input type="checkbox"/><br>Turning Sequence <input type="checkbox"/> |
| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                   |

## 5.0 PARTS LIST

| Qty<br>-117A | Qty<br>-119 | Qty<br>-133 | Part Number   | Description                                    |
|--------------|-------------|-------------|---------------|------------------------------------------------|
| X            |             |             | D350-591-117A | <i>Hel-Access-Step</i> ™, Pre-Flight Step      |
|              | X           |             | D350-591-119  | <i>Hel-Access-Step</i> ™, Long Step – Low Skid |
|              |             | X           | D350-591-133  | <i>Hel-Access-Step</i> ™, Aft Maintenance Step |
|              | 1           |             | D2355         | STEP ASSEMBLY (LOW-LONG)                       |
|              |             | 1           | D2946-041     | STEP ASSEMBLY (MAINTENANCE)                    |
| 2            | 2           |             | D2171         | CLAMP                                          |
| 2            | 2           |             | D2182B035     | CUSHION                                        |
|              |             | 4           | D2230-1       | MOUNTING LUG                                   |
|              |             | 4           | D2230-3       | MOUNTING LUG                                   |
| 4            | 4           |             | D2274         | RADIUS BLOCK                                   |
| 1            |             |             | D2362-041     | SUPPORT BRACKET                                |
|              | 1           |             | D2362-3       | SUPPORT BRACKET                                |
|              |             | 1           | D2945         | MOUNTING PLATE                                 |
| 1            | 1           |             | D3595-200-300 | CUSHION                                        |
|              |             | 8           | D2732-030     | CUSHION                                        |
|              | 2           |             | AN3-37A       | BOLT                                           |
|              |             | 2           | AN4-7A        | BOLT                                           |
|              |             | 4           | AN4-11A       | BOLT                                           |
|              |             | 8           | AN4-16A       | BOLT                                           |
|              | 4           |             | AN4-21A       | BOLT                                           |
| 4            | 1           |             | AN4-22A       | BOLT                                           |
|              | 4           |             | NAS1149D0363J | WASHER (AN960JD10)                             |
| 4            | 6           | 14          | NAS1149D0463J | WASHER (AN960JD416)                            |
|              | 2           |             | MS21042L3     | NUT                                            |
| 4            | 5           | 14          | MS21042L4     | NUT                                            |

| Qty<br>-121 | Qty<br>-122 | Qty<br>-123 | Qty<br>-124 | Part Number   | Description                                          |
|-------------|-------------|-------------|-------------|---------------|------------------------------------------------------|
| X           |             |             |             | D350-591-121  | <i>Hel-Access-Step</i> ™, Short Step – High Skid, LH |
|             | X           |             |             | D350-591-122  | <i>Hel-Access-Step</i> ™, Short Step – High Skid, RH |
|             |             | X           |             | D350-591-123  | <i>Hel-Access-Step</i> ™, Short Step – Low Skid, LH  |
|             |             |             | X           | D350-591-124  | <i>Hel-Access-Step</i> ™, Short Step – Low Skid, RH  |
| 1           |             |             |             | D2351-041     | STEP ASSEMBLY (HIGH-SHORT, LH)                       |
|             | 1           |             |             | D2351-042     | STEP ASSEMBLY (HIGH-SHORT, RH)                       |
|             |             | 1           |             | D2356-041     | STEP ASSEMBLY (LOW-SHORT, LH)                        |
|             |             |             | 1           | D2356-042     | STEP ASSEMBLY (LOW-SHORT, RH)                        |
| 1           | 1           | 1           | 1           | D2230-1       | MOUNTING LUG                                         |
| 1           | 1           | 1           | 1           | D2230-3       | MOUNTING LUG                                         |
| 2           | 2           | 2           | 2           | D2732-030     | CUSHION                                              |
| 2           | 2           | 2           | 2           | AN3-37A       | BOLT                                                 |
| 1           | 1           | 1           | 1           | AN4-13A       | BOLT                                                 |
| 2           | 2           | 2           | 2           | AN4-16A       | BOLT                                                 |
| 4           | 4           | 4           | 4           | NAS1149D0363J | WASHER (AN960JD10)                                   |
| 6           | 6           | 6           | 6           | NAS1149D0463J | WASHER (AN960JD416)                                  |
| 2           | 2           | 2           | 2           | MS21042L3     | NUT                                                  |
| 3           | 3           | 3           | 3           | MS21042L4     | NUT                                                  |